

**Ship Via:**

				QC 8 - 76	
				QC 8 - 61	
130	Crosstubes - 2 - B4B	12 pcs	1/20/20	0.00	2.00
				Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	
140	QC 3	12 pcs	1/20/20	0.00	0.00
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	12 pcs	1/20/20	0.00	0.00
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	

RD 20-2-12

DAS
41 FEB 13 2020
3-89DAS
41 FEB 13 2020
4-80

					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	12 pcs	1/20/20	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	3-85
					Broussard	

FEB 13 2020

Part Op 100 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA081
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Crosstubes) Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 5206999
 140 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____) LOCATION: LG050
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK078	D2893-1 Turning Detail	6 pcs (.5 ea)	100-HAAS 4 Axis	5244325

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK078	6	0	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

Plex 12/2/19 8:31 AM Dart.Renwick.Jennifer

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 203995
Description: Support		Part Number: D2893-1
Inspection Dwg:	Rev: D	Page 1 of 1

INSPECTION DIMENSION

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	.125	.160		.140	.140	.150	.148	.147
AB	.040	.060		.049	.049	.049	.047	.052
AC	.260 ϕ	.266 ϕ		.261 ϕ	.261 ϕ	.261	.261	.261
AD	.187 ϕ	.193 ϕ		.190 ϕ	.190 ϕ	.190	.190	.190
AE	.240	.260		R.250 α	R.250 α	A.250	.250	.250
AF	1.347	1.407		1.374	1.373	1.373	1.374	1.374
AG	1.200	1.240		1.214	1.213	1.205	1.203	1.206
AH	.147	.167		.159	.159	.158	.160	.159
AI	2.985	3.005		2.995	2.994	2.995	2.992	2.994
AJ	.400	.500		.465	.460	.500	.460	.460
AK	4.930	4.990		4.960	4.960	4.960	4.960	4.961
AL	.125	.160		.139	.141	.140	.138	.142
AM	.053	.073		R.063 α	R.063 α	.063	.063	.063
AN	.240	.260		R.250 α	R.250 α	.250	.250	.250
AO	.021	.041		R.032	R.032	.032	.032	.032
AP	.150	.180		.173	.173	.173	.172	.174
AQ	.053	.073		R.063 α	R.063 α	.063	.063	.063
AR	2.302	2.322		2.322	2.322	2.320	2.318	2.319
AS	.0140	.0160		.147	.147	.147	.148	.147
AT	.040	.060		.051	.051	.051	.049	.050
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that ϕ " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by: M.M. / mml	Checked by: [Signature]	QC Inspector:
Date: 2020/02/06	Date: 20/02/11	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	15.04.27	New Issue	KJ	

DART AEROSPACE LTD		Work Order: 203995
Description: Ø Support		Part Number: D2893-1
Inspection Dwg: D2893-1 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	.125	.160		.150	.140	.142	.140	.140
AB	.040	.060		.050	.049	.050	.048	.052
AC	.260 Ø	.266 Ø		.261	.261	.261	.261	.261
AD	.187 Ø	.143 Ø		.196	.190	.140	.196	.190
AE	.240	.250		.250	.250	.250	.250	.250
AF	1.347	1.407		1.324	1.324	1.324	1.324	1.324
AG	1.200	1.240		1.206	1.206	1.206	1.204	1.200
AH	.147	.167		.158	.159	.159	.162	.156
AI	2.985	3.005		2.993	2.992	2.994	2.991	2.992
AJ	.400	.500		.460	.460	.460	.460	.460
AK	4.930	4.990		4.963	4.962	4.961	4.962	4.962
AL	.125	.160		.137	.138	.142	.142	.150
AM	R-.053	R-.073		.063	.063	.063	.063	.063
AN	R-.240	R-.266		.250	.250	.250	.250	.250
AO	R-.021	R-.041		.032	.032	.032	.032	.032
AP	.150	.150		.146	.169	.174	.174	.170
AQ	.053	.073		.063	.063	.063	.063	.063
AR	2.302	2.322		2.320	2.317	2.319	2.317	2.317
AS	.140	.160		.146	.145	.145	.146	.150
AT	.040	.060		.051	.051	.051	.048	.049
AU								
AV								
AW								
AX								
AY								
AZ								

Ensure that Ø " bore is perpendicular to " bore within "

Accept/Reject

Measured by: <i>gmyrc</i>	Date: 20/02/08
Audited by: <i>gmk</i>	Date: 20/02/11
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.24	New Issue	KJ/JLM	
B	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order: 203995
Description: Ø Support		Part Number: D2893-1
Inspection Dwg: D2893-1 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1φ	12	13	14	15
HAAS Section								
AA	.125	.160	.155	.147	.145	.145	.148	.145
AB	.040	.060		.048	.048	.045	.048	.046
AC	260 φ	266 φ		.261	.261	.261	.261	.261
AD	187 φ	193 φ		.190	.190	.190	.190	.190
AE	.240	.250		.250	.250	.250	.250	.250
AF	1.347	1.407		1.374	1.374	1.374	1.374	1.374
AG	1.200	1.240		1.210	1.209	1.207	1.206	1.203
AH	.147	.167		.161	.162	.158	.162	.159
AI	2.985	3.065		2.996	2.994	2.994	2.994	2.996
AJ	.400	.500		.460	.460	.460	.460	.460
AK	4.930	4.990		4.960	4.961	4.960	4.960	4.960
AL	.125	.160		.140	.143	.138	.137	.138
AM	R-.053	R-.073		.067	.067	.063	.063	.063
AN	R-.240	R-.260		.250	.250	.250	.250	.250
AO	R-.021	R-.041		.032	.032	.032	.032	.032
AP	.150	.180		.170	.172	.174	.173	.173
AQ	.053	.073		.067	.063	.063	.063	.063
AR	2.302	2.322		2.319	2.319	2.318	2.318	2.317
AS	.140	.160		.148	.145	.147	.146	.147
AT	.040	.060		.051	.047	.052	.049	.051
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by: <i>mm</i>	Date: 20/02/08
Audited by: <i>mk</i>	Date: 20/02/11
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.24	New Issue	KJ/JLM	
B	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order: 203995
Description: Ø Support		Part Number: D2893-1
Inspection Dwg: D2893-1 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				106	217	318	419	520
HAAS Section								
AA	.125	.160		.151	.145	.151	.141	.142
AB	.040	.060		.047	.047	.046	.048	.048
AC	260 Ø	266 Ø		.261	.261	.261	.261	.261
AD	187 Ø	193 Ø		.190	.190	.190	.190	.190
AE	.240	.250		.250	.250	.250	.250	.250
AF	1.347	1.407		1.374	1.374	1.374	1.374	1.374
AG	1.200	1.240		1.208	1.208	1.209	1.210	1.205
AH	.147	.167		.162	.160	.161	.160	.160
AI	2.985	3.065		2.996	2.996	2.996	2.996	2.996
AJ	.400	.500		.460	.460	.460	.460	.460
AK	4.930	4.990		4.960	4.960	4.960	4.960	4.960
AL	.125	.160		.138	.135	.137	.134	.138
AM	R.053	R.073		.063	.063	.063	.063	.063
AN	R.240	R.260		.250	.250	.250	.250	.250
AO	R.021	R.041		.032	.032	.032	.032	.032
AP	.150	.180		.177	.174	.172	.171	.171
AQ	.053	.073		.063	.063	.063	.063	.063
AR	2.302	2.322		2.317	2.317	2.317	2.318	2.318
AS	.140	.160		.149	.147	.149	.147	.147
AT	.040	.060		.051	.050	.051	.053	.049
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within " Accept/Reject								

Measured by: gml	Date: 20/02/08
Audited by: gml	Date: 20/02/08
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.24	New Issue	KJ/JLM	
B	12.07.31	Prototype revised to preliminary	KJ	